

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001448**Date Inspected:** 13-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** See Below**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 Interior Longitudinal Stiffener Plates	NA	NA	Work In Progress

114M (upper tower shaft) Mock-up: Caltrans QA Inspector observed ZPMC shop workers drilling interior longitudinal stiffener connection plates. The connection plates were identified as A63. ZPMC workers were observed match drilling the connection plate using a magnetic drill with an annular drill bit. The drilling of the connection plates appeared to be in general conformance with the Tower Splice Mock-up Fabrication Procedure. Following digital picture illustrates the drilling in progress at the work station.

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## WELDING INSPECTION REPORT

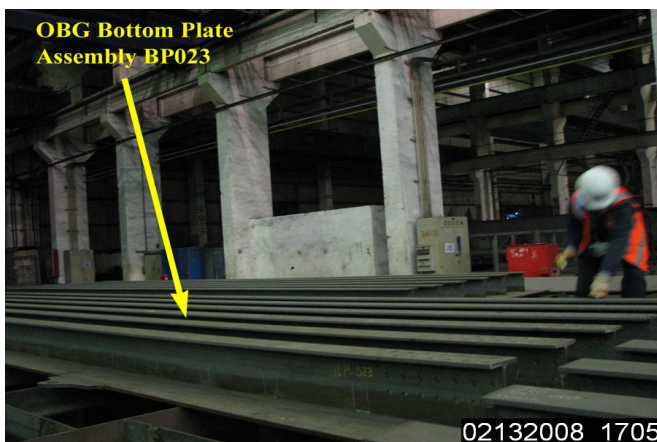
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- 2 Bottom Plate Assembly NA NA NA

OBG: Caltrans QA Inspector observed tack welds on bottom plate (BP023) assembly in Bay 3. The assembly is approximately 15180 millimeters long with six split tees tack welded to the plate. The tees will be joined to the bottom plate, full length, 10 mm (millimeter) fillet weld, both sides. Caltrans QA Inspector observed that the tack welds joining the tees to the bottom plate appeared to be in general conformance with the project requirements. The following digital picture illustrates the bottom plate assembly.



### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

**Reviewed By:** Cuellar, Robert

QA Reviewer